



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-151
Job Sheet 195405



Part No: D206-642-151

Job Qty: 1 pcs

Part Name: Replacement Skidtube, Low Gear with Run-on Landing Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/21/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 6/7/19

Description:

Note: DWG D3804 REV A(CEO), IIN-D206-642 REV Q SHEETS 13,26 IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC IPP REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP Rev:C 12.11.22 now swage per ecn12-679 DD verf:JLM IPP Rev:D 14.04.24 ECN14-520 DD verf:JLM IPP Rev:E 16.04.04 as per CHG004(ecn16-553) DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	6/7/19		0.00	1.82	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	1 pcs	6/7/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
130	QC 9	1 pcs	6/7/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS	
							QC 9 - 43	24	
							QC 9 - 58	9-89	

MAY 27 2019

MAY 27 2019

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140 Handfinish - 1-1 Chemical- B4B	1 pcs	6/7/19	0.00 0.33	QC 9 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ MAY 29 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	6/7/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	★
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	

160 Skidtubes - 2 - B4B	1 pcs	6/7/19	0.00 2.00	QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				Skidtubes - 1 - B4B	99
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
180 Skidtubes - 3 - B4B	1 pcs	6/7/19	0.00 1.82	Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				Skidtubes - 1 - B4B	100
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
190 QC 5	1 pcs	6/7/19	0.00 0.00	Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 Skidtubes - 4 - B4B	1 pcs	6/7/19	0.00 2.84	Skidtubes - 1 - B4B	100
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
215 QC 9	1 pcs	6/7/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	DAS
				QC 9 - 43	24
				QC 9 - 50	9-89
				QC 9 - 9	
230 QC 5	1 pcs	6/7/19	0.00 0.00	QC 9 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	JUN 10 2019
				QC 5 - 3	
				QC 5 - 43	DAS
				QC 5 - 49	24
				QC 5 - 51	9-89
				QC 5 - 58	

240 Handfinish - 4-1-Assembly-B4B	1 pcs	6/7/19	0.00 0.78	QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	★ JUN 12 2019
250 Powdercoat - 1 White GI(A)- B4B	1 pcs	6/7/19	0.00 0.25	Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
260 QC 3	1 pcs	6/7/19	0.00 0.00	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	6/7/19	0.00 1.00	QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 -	

DAS
15
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				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 Handfinish - 3-1- WingWalk-B4B	1 pcs	6/7/19	0.00 0.60	Handfinish - 3 - 1 - B4B	11 19-6-21
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
290 QC 3	1 pcs	6/7/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	JUL 26 2019 DAS 40 9-89
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
300 QC 5	1 pcs	6/7/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
QC 5 - 30					
QC 5 - 40	JUL 26 2019 DAS 40 9-89				
310 Packaging 3-1 - Stock - B4B	1 pcs	6/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Plex 5/21/19 3:28 PM Dart.lajeunesse.marie	

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
315 DC - 1 - B4B	1	6/7/19	0.00 0.00	DC - 1 - B4B	21 AUG 22 2019
	pcs			DC - 2 - B4B	9-89
320 QC 21 - FG	1	6/7/19	0.00 0.00	QC 21 - FG - 21	DAS
	pcs			QC 21 - FG - 70	21 AUG 22 2019

Part Op 110 - Skid tubes - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld
 Descriptions: Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. *MR M139011 / M138989*

120 - QC5- Inspect part completeness to step on W/O

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - Skid tubes - 1-Open holes of detail B to finished size as per Dwg DEO D3804, (without cutting fluid) 2-C'sink one crossbolt spacer hole as per Dwg D3804 DEO Detail B (without cutting fluid) 3-Deburr and blow out all chips from inside the tube

180 - Skid tubes - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

190 - QC5- Inspect part completeness to step on W/O

200 - 1-Remove alodine in one area see DEO Detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004, and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. *AK M138989*

215 - QC9- Inspect visual per QSI004- Fusion Welds

230 - QC5- Inspect part completeness to step on W/O

240 - Pressure Wash per QSI005 4.3/ Clean and remove all markings) HandFinish4 Assemble as per dwg

250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____

260 - QC3- Inspect Part Finish

270 - HandFinish4 (Assemble as per dwg - 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and Install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - Wing Walk as per dwg QSI005 4.4 Batch *585147* 4-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

290 - QC3- Inspect Part Finish

300 - QC5- Inspect part completeness to step on W/O

310 - Identify and pack for shipping as per PPP D206-642-151 Location :FG107

315 - Document Control - Photocopy bluefile & type labels per PPP D206-642-151 CHG004
 320 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	5165744
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5166098
CR3212-4-04	Cherry Rivet	52 Ea (52 ea)	180-Skidtubes - 3 - B4B	5171694
D2654-1	Web	1 pcs (1 ea)	180-Skidtubes - 3 - B4B	5164714
D3286-1	Doubler	2 pcs (2 ea)	180-Skidtubes - 3 - B4B	5058750
D2649	Cross Bolt Spacer	1 pcs (1 ea)	200-Skidtubes - 4 - B4B	5156881
D3286-3	Spacer	2 pcs (2 ea)	200-Skidtubes - 4 - B4B	5140137
D4720-1	Spacer	18 pcs (18 ea)	200-Skidtubes - 4 - B4B	5173034
D2651-1	Plug	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5167921
D2651-3	O-Ring	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5044602
D2680-041	Nut Plate	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5141543
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5141321
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5141321
AN3-37A	Bolt	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	5166888
D2646	Aft Cap	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5168607
D3805-041	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5187217
D3805-045	Run-on Landing Wearplate Aft	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5187707
D3873-1	Bushing	14 pcs (14 ea)	280-Handfinish - 3-1- WingWalk-B4B	5175770
MS21042L3	Nut	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	5157462
MS27039-1-08	Screw	2 Ea (2 ea)	280-Handfinish - 3-1- WingWalk-B4B	5167302
MS27039-4-06	Screw	1 Ea (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5167302
NAS1149D0332J	Washer	2 Ea (2 ea)	280-Handfinish - 3-1- WingWalk-B4B	5166241
NAS1149D0363J	Washer	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	5166241
NAS1149D0463J	Washer	1 Ea (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5055951

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	6	0
	D2647	1	45	0
180-Skidtubes - 3 - B4B	CR3212-4-04	52	747	0
	D2654-1	1	5	0
	D3286-1	2	34	0
200-Skidtubes - 4 - B4B	D2649	1	70	0
	D3286-3	2	24	0
	D4720-1	18	222	0
270-Handfinish - 4-2-Assembly-B4B	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D2651-1	6	95	0
	D2651-3	6	322	0
	D2680-041	1	12	0
280-Handfinish - 3-1- WingWalk-B4B	AN3-37A	7	71	0
	D2646	1	39	0
	D3805-041	1	3	0
	D3805-045	1	0	0
	D3873-1	14	92	0
	MS21042L3	7	2,464	0
	MS27039-1-08	2	475	0
	MS27039-4-06	1	95	0
	NAS1149D0332J	2	3,738	0
	NAS1149D0363J	7	1,582	0
	NAS1149D0463J	1	3,551	0

Part Specifications

Specifications could not be found.

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ITEM	Qty	Qty	Part Number	Description
1	X	-043	D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
8	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11	1	1	D2654-3	WEB
12	1	1	D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3266-1	DOUBLER
15	2	2	D3266-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD16	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	62	62	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-08	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/281 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE)

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125405 MWS
19-05-22

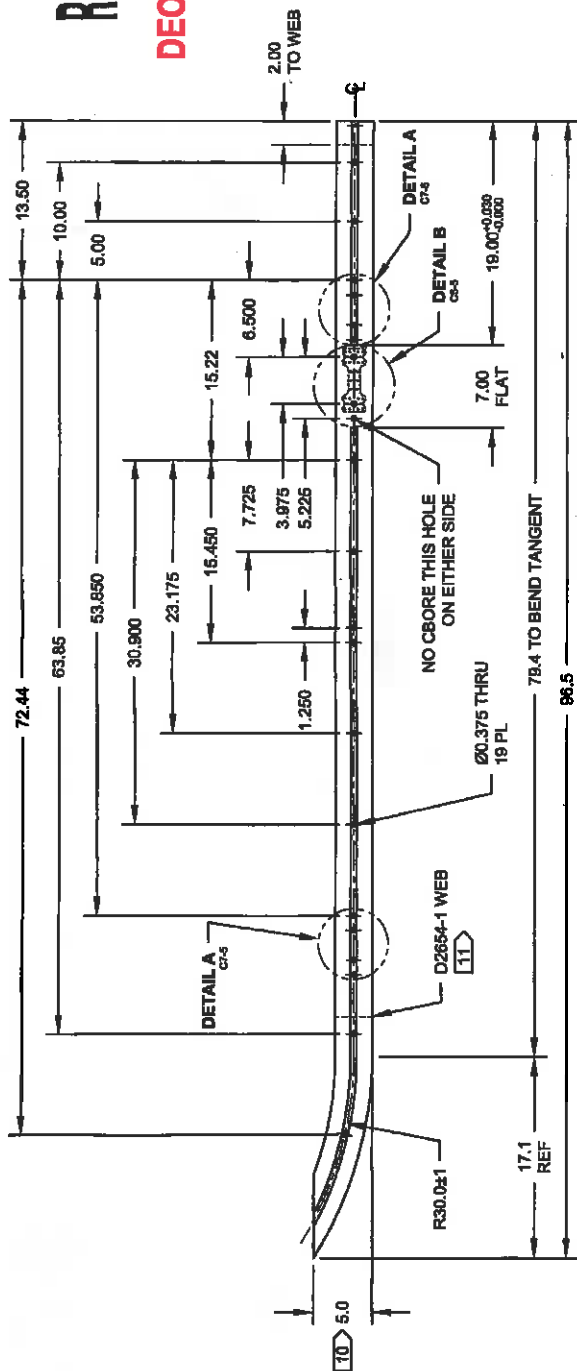
DEO ATTACHED

RELEASED
R 11-03-03
per E2-01-536

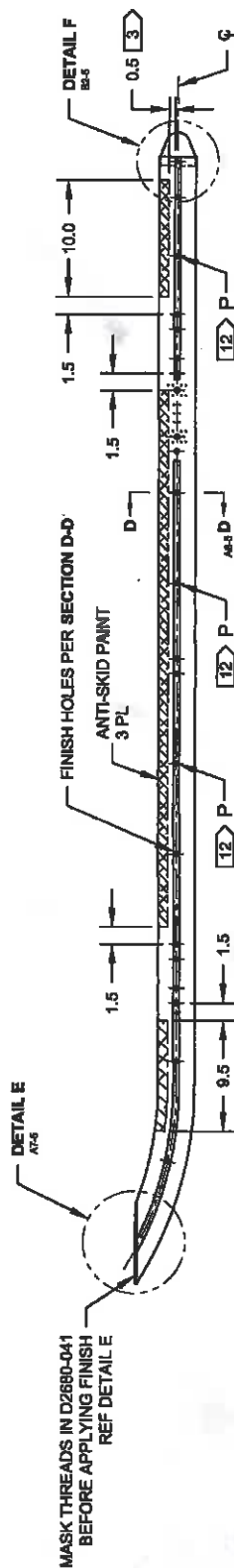
A	NEW ISSUE	MB	BY	DATE
REV.	DESCRIPTION			
DESIGN	1	DART AEROSPACE USA, INC		
DRAWN	1	PORT HADLOCK, WA		
CHECKED	1	DRAWING NO.		
MFG. APPR.	1	D3804		
APPROVED	1	TITLE		
DE APPR.	1	SKIDTUBE ASSEMBLY, 206A/B		
DATE	08.07.07	SHEET 1 OF 5		
		SCALE		
		NTS		

COMPONENT IS PART OF DART AEROSPACE USA, INC
PROPERTY OF DART AEROSPACE USA, INC
NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM
WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC

DEO ATTACHED



D3804-041 BENDING/DRILLING DETAIL



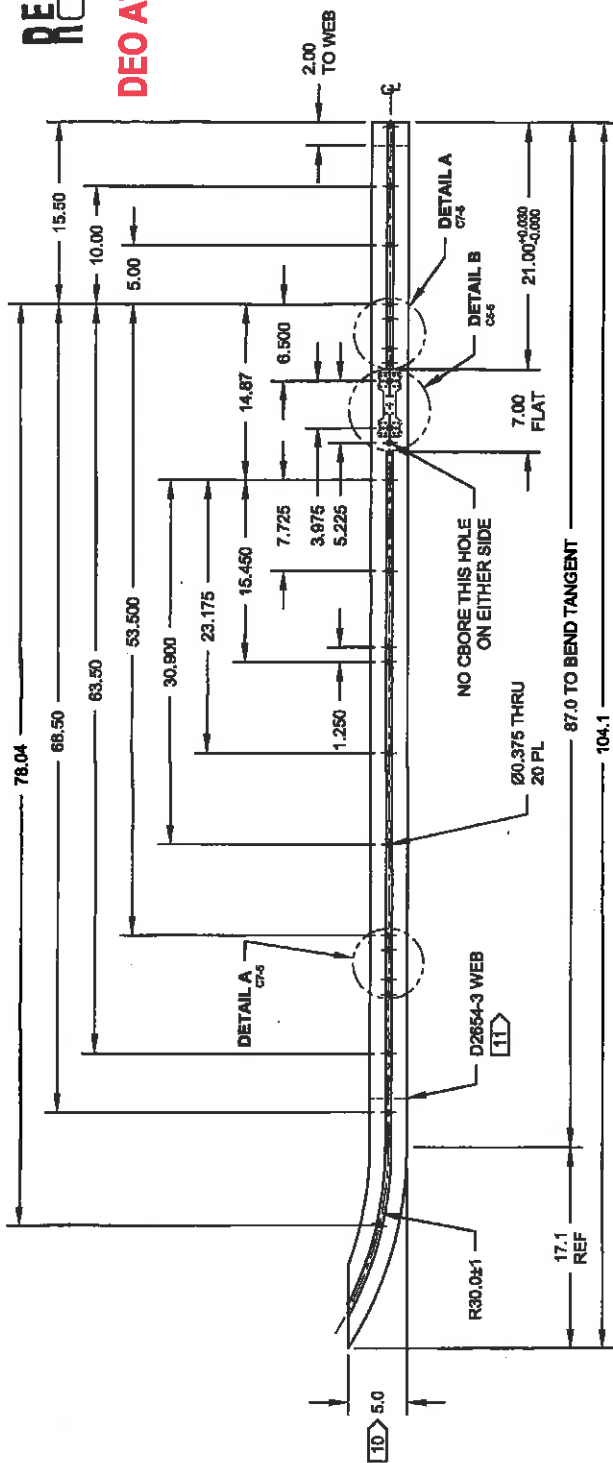
D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	41	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3804 REV. A SHEET 2 OF 5 SCALE NTS
DRAWN	41	
CHECKED	41	
MFG. APPR.	41	
APPROVED	41	
DATE	08.07.07	SKIDTUBE ASSEMBLY, 206A/B COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED ONLY FOR THE PROJECT AND FOR THE QUANTITY SPECIFIED. IT IS NOT TO BE COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.

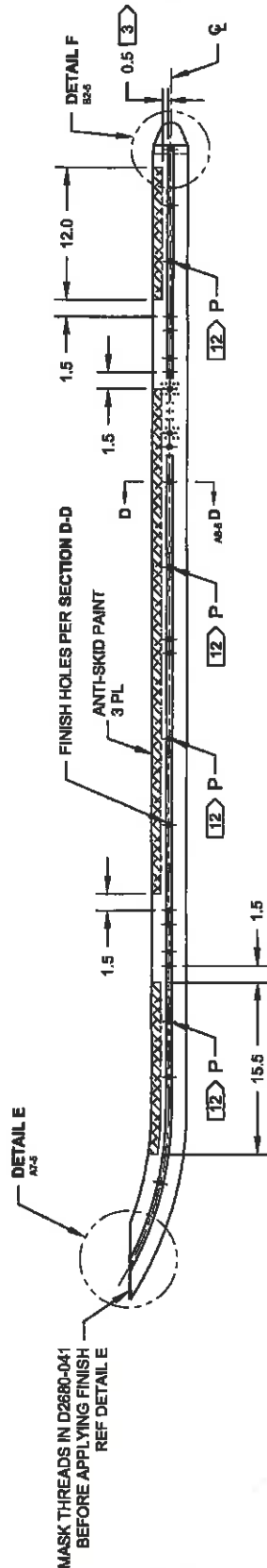
RELEASED

DEO ATTACHED

1 2 3 4 5 6 7 8



D3804-043 BENDING/DRILLING DETAIL



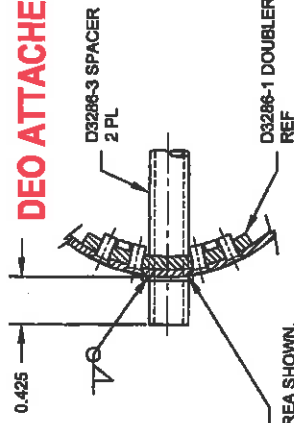
D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	01	DART AEROSPACE USA, INC	REV. A
DRAWN	01	PORT HADLOCK, WA	SHEET 3 OF 3
CHECKED	01	D3804	SCALE
MFG. APPR.	01	TITLE	SKIDTUBE ASSEMBLY, 206A/B
APPROVED	01	DATE	08.07.07
DE APPR.	01		

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RELEASED

DEO ATTACHED

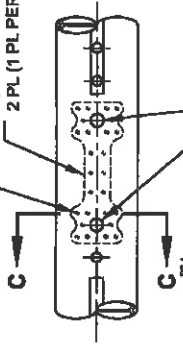


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C CS-4
PARTIAL SECTION
SCALE NONE

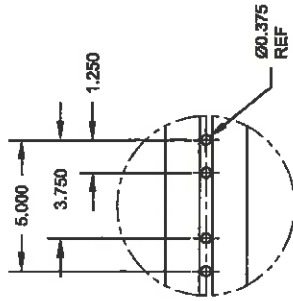
Ø0.128 THRU WALL
CSINK Ø0.228 X 100°
INSTALL CR3212-4-04 RIVET
E2 PL (26 PL PER DOUBLER)

D3286-1 DOUBLER
2 PL (1 PL PER SIDE)

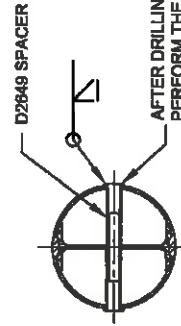


ENLARGE TO Ø0.500 IN D3286-1
ENLARGE TO Ø0.625 IN TUBE
4 PL (2 PL PER SIDE)

DETAIL B CS-2
CS-3
SCALE NONE



DETAIL A D3-4
CS-4
D3-3
CS-3
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2849 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORER TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	44	DART AEROSPACE USA, INC
DRAWN	44	PORT MADLOCK WA
CHECKED	44	DRAWING NO.
MFG. APPR.	44	D3804
APPROVED	44	TITLE
DE APPR.	44	SKIDTUBE ASSEMBLY, 206A/B
DATE	08.07.07	SCALE
		NTS

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R 09.03.03

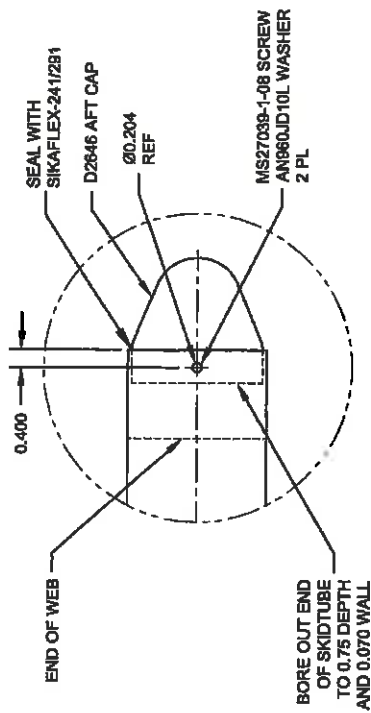
DEO ATTACHED

CR3212-4-03 RIVET
2 PL

CCR284SS3-3
RIVET
2 PL

VIEW G-G
SCALE NONE

47.5



DETAIL F
SCALE NONE

85.2
85.3

- D2847 CAP. TO INSTALL:
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2847 (TRIM AS REQD)
 4. WELD D2847 IN PLACE
 5. GRIND FLUSH
 6. RIVET D2880-041 NUT PLATE
IN PLACE

MS27039-4-08 SCREW
AN980JD418 WASHER
D2880-041
NUT PLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

DETAIL E
SCALE NONE

87.2
87.3

DESIGN	01	DART AEROSPACE USA, INC
DRAWN	1	PORT HADLOCK, WA
CHECKED	0	REV. A
MFG. APPR.	0	DRAWING NO. D3804
APPROVED	0	SHEET 5 OF 5
DE APPR.	0	TITLE
DATE	08.07.07	SKIDTUBE ASSEMBLY, 206A/B
		SCALE NTS

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DRAWING NO. D3804	TITLE SKIDTUBE ASSEMBLIES, 206A/B	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3804-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED A.P.	DATE 12.10.22	MFG. APPR.	APPROVED	DATE 12.10.22	DE APPR.	
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22

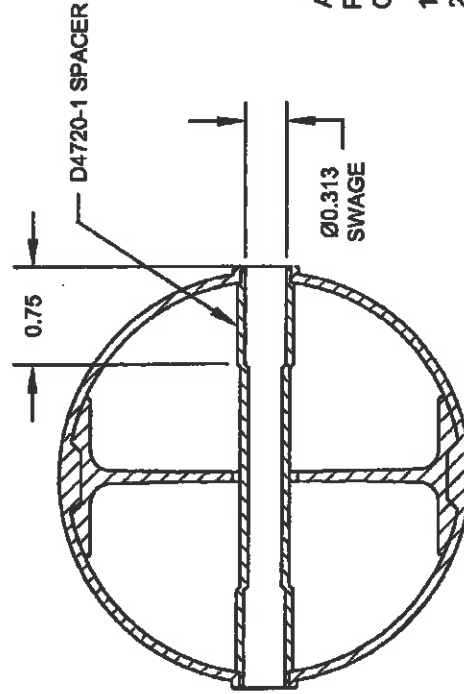
PURPOSE:
CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:
PARTS LIST IS AMENDED AS FOLLOWS:

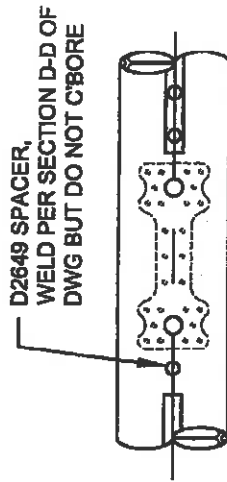
QTY	QTY	PART NUMBER	DESCRIPTION
1	1	D2649	CROSS BOLT SPACER
18	19	D4720-1	SPACER

QTY	QTY	PART NUMBER	DESCRIPTION
19	20	D2649	CROSS BOLT SPACER

ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG. C'BORED HOLES ARE NOW SWAGED PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



SECTION H-H
FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE



DETAIL B
AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	
Date :		Sequence #:		QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition					
Completed By		Lead hand / Supervisor					
QC / QA Coordinator							
Root Cause		FAULT CATEGORY					
Operator ☐		Pressure/Forced ☐		Contamination ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐			
Human Factors ☐		Other/Details:					